

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020570**Date Inspected:** 12-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Qiu Wen.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS)

Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA Inspector observed and/or found the following:

Bay 14:

This QA Inspector observed the following work in progress:

OBG Seg 14W:

The Flux Cored Arc Welding (FCAW) process on weld joint no: DP3177-001-246 [Deck Plate (DP) to Diaphragm, fillet weld]. The welder is identified as 203781 and was observed welding in the 2G position. ABF QA was identified as Shen Jian. The welding variables recorded by QC appeared to comply with WPS: B-T-2232-ESAB.

The Shielded Metal Arc Welding (SMAW) process on weld joint no: DP3173-001-024 [DP to DP diaphragm, complete joint penetration(CJP) weld]. The welder is identified as 066443 and was observed welding in the 2G position. ABF QA was identified as Shen Jian. The welding variables recorded by QC appeared to comply with WPS: B-P-2212-TC-U4b-FCM.

The SMAW process on weld joint no: DP3173-001-021 (DP to DP diaphragm, CJP weld). The welder is identified

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as 037779 and was observed welding in the 2G position. ABF QA was identified as Shen Jian. The welding variables recorded by QC appeared to comply with WPS: B-P-2212-TC-U4b-FCM.

The SMAW process on weld joint no: DP3174-001-020 (DP to DP diaphragm, CJP weld). The welder is identified as 067520 and was observed welding in the 2G position. ABF QA was identified as Shen Jian. The welding variables recorded by QC appeared to comply with WPS: B-P-2212-TC-U4b-FCM.

The SMAW process on weld joint no: DP3174-001-018 (DP to DP diaphragm, CJP weld). The welder is identified as 066674 and was observed welding in the 2G position. ABF QA was identified as Shen Jian. The welding variables recorded by QC appeared to comply with WPS: B-P-2212-TC-U4b-FCM.

The SMAW process on weld joint no: Seg3020U-588 [Vertical Anchor Plate (AP) to Bottom Plate, CJP weld]. The welder is identified as 067904 and was observed welding in the 2G position. ZPMC QC was identified as Zhu Lin. The welding variables recorded by QC appeared to comply with WPS: B-P-2212-TC-U4b-FCM.

OBG Seg 13CW:

The FCAW process on weld joint no: Seg3015B-005 [DP Diaphragm (of DP3149A) to Floor Beam (FB) 3233A, at Panel Point (PP) 124.5, CJP weld]. The welder is identified as 067888 and was observed welding in the 2G position. ABF QA was identified as Cao Hai Zhao. The welding variables appeared to comply with WPS: B-T-2232-ESAB.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

Inspected By:	Wadkar,Sailesh	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
